

5/1-3

DART AEROSPACE LTD.	Work Order:	22525
Description: STA 155 bracket	Part Number:	D2804-1
Dwg: D2803 rev. A	Qty:	20

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	AF	05.02.23	20
2	METAL	Cut blanks per template DT8534 Material: 6061-T6 bar 12.00" x 0.50"	EC 00.11.02 M9601	05.03.08	20
3	HAAS	Machine as per folio FA103 Batch: <del>M10623</del> M16953 M10627	B6	05/03/18	20
4	QC	Inspect Level 2	EP	05/03/18	20
5	QC	Inspect Level 8	EP	05/03/18	20
6	METAL	Tumble & Deburr	B6	05/03/21	20
7	QC	Inspect Level 5	EP	05/03/21	20
8	FINISHING	Chemical conversion coat per QSI 005	CPL	05-03-21	20
9	STORES	Identify and stock	ml	05-03-22	20
10	EXPEDITING	Close W/O Cost / part: 50.50 545 05/03/28 20	KY	05.04.05	20

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	EC

RELEASED

EC 00.11.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

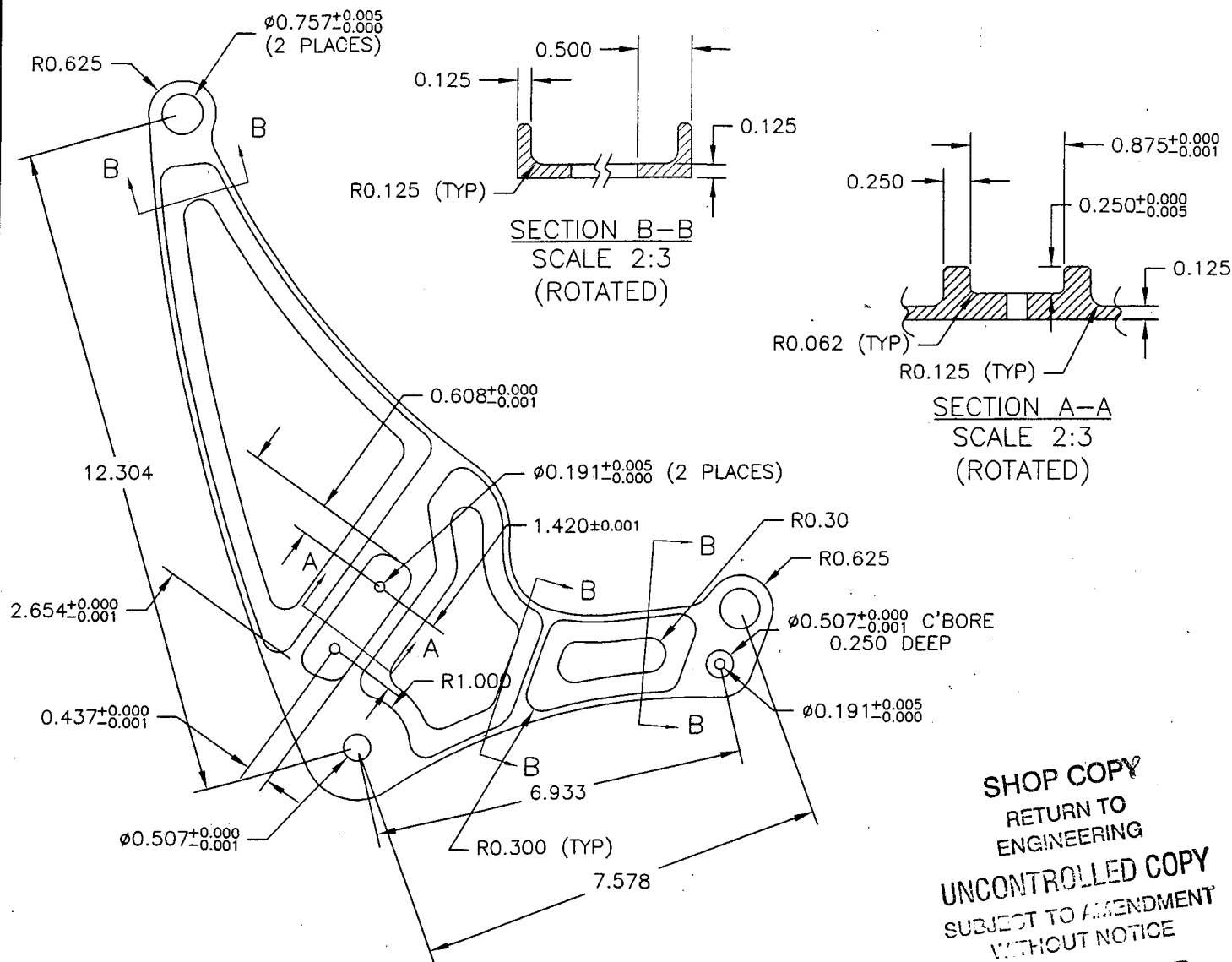
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

9

DESIGN CP		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2804 REV. B SHEET 1 OF 2	
DATE 04.11.22		TITLE STA 155 BRACKET		SCALE 1:3	
A	00.11.07		NEW ISSUE		
B	04.11.22		ADD CUTOUTS & -043/-044		



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 22525

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 22, 2005  
03:39 pm

Work Order No : 0022525  
Project Name : D2804-1  
Project For : WK513  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2804-1  
Description : STA 155 Bracket  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 02-22-05  
Est Finish Date : 03-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 22525
Description: STA 155 Bracket		Part Number: 02804-1
Inspection Dwg: 02804 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.625	±.010	.626	—			Vernier
Ø.757 <sup>+0.005</sup> / <sub>-0.000</sub>		.759	—			
.608 <sup>+0.000</sup> / <sub>-0.001</sub>		.608	—			
Ø.191 <sup>+0.005</sup> / <sub>-0.000</sub>		.192	—			
1.420 ±.001		1.420	—			
Ø.507 <sup>+0.006</sup> / <sub>-0.001</sub>		.507	—			
.250 dec	±.010	.245	—			
Ø.507 <sup>+0.000</sup> / <sub>-0.001</sub>		.5065	—			Mic
Ø.191 <sup>+0.005</sup> / <sub>-0.000</sub>		.192	—			Vernier
6.933	±.010	6.932	—			
7.578	±.010	7.578	—			
.437 <sup>+0.000</sup> / <sub>-0.001</sub>		.437	—			
2.654 <sup>+0.000</sup> / <sub>-0.001</sub>		2.654	—			
12.304	±.010	12.304	—			Tape
.125	±.010	.126	—			Vernier
.500	±.010	.500	—			
.125	±.010	.127	—			
.250	±.010	.250	—			
.875 <sup>+0.000</sup> / <sub>-0.001</sub>		.8745	—			Mic
.250 <sup>+0.000</sup> / <sub>-0.005</sub>		.245	—			Vernier

Measured by: B.G.	Audited by:	Prototype Approval: N/A
Date: March 16, 05	Date: 5/6/3/16	Date:

Rev A	Date:	Change New Issue	Revised by KJ/JLM	Approved
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